

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011112**Date Inspected:** 13-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Chen Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-**BAY #11:-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as North Tower Lift 3. The weld designations reviewed are as follows:-

NSTL3-3G/K-155

IN PROCESS INSPECTION:-**BAY #10:-**

This QA inspector observed the following work in progress:

SAW welding of weld joint no: NSTL4-3B/L-4A located on AB Corner Seam. Welder is identified as 040460.

ZPMC CWI is identified as Mr. Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2b-S-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA3-2-99M-2-25 located on Strut Plate. Welder is identified as 066155.

ZPMC CWI is identified as Mr. Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

WELDING INSPECTION REPORT

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BAY #11:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-SPSA4-2-2B located on Interior Splice Plate. Welder is identified as 053316.ZPMC CWI is identified as Mr. Yu Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-SPSA4-30-2A located on Interior Corner Splice Assembly Plate. Welder is identified as 058792.ZPMC QC is identified as Mr.Fu wei min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U5-F.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-STSA3-2-89M-1-30 located on Strut Plate. Welder is identified as 049099. ZPMC CWI is identified as Mrs. Yu dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

This QA inspector observed the following work in progress:

Welding of weld joint – SD1-A6002-6-7A/B located on Strut Plate. Welder is identified as 040733. ZPMC CWI is identified as Mrs.Yu dong ping. Welding was been performed against Critical Welding Repair Report T-CWR485 and UT report number- T787-UT-2481R1.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

This QA inspector observed ZPMC qualified welding personnel identified as 046704 perform weld repair on “AE” Corner Seam. The WWR Report number is T-WR-2729. SMAW welding of weld joint no: ESTL4-2B/L-60A/B. ZPMC QC Identified as Mr. Yuan wen jie. The welding parameters as measured using QC’s calibrated instruments appeared to be in general compliance with the WPS- SMAW-345-2G(2F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge,Sinevod-13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
